



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE350A94-3700-C-01
Job Sheet 193408



Part No: RBE350A94-3700-C-01

Job Qty: 10 pcs

Part Name: Tube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/15/19

Job Tracking No:

Due Date: 5/3/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE350A94-3700-C-01 Rev 6 IPP Rev A 18.01.15 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
110	SL-154 - 1	10 pcs	5/3/19	5/3/19	0.00	2.50	SL-154 - 1	JB 19-06-17
120	QC 2	10 pcs	5/3/19	5/3/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	JB 19-06-17
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	
							QC 2 - 65	

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Container No: S191162

Part: RBE350A94-3700-C-01

Job No: 193408

Serial No/Batch: S191162

Revision: 6

Inspector:

Exp Date:

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130 QC 8

10 pcs

5/3/19

0.00 0.00

QC 2 - 5

QC 2 - 71

QC 8 - 12

QC 8 - 14

QC 8 - 17

QC 8 - 20

QC 8 - 25

QC 8 - 3

QC 8 - 32

QC 8 - 33

QC 8 - 35

QC 8 - 39

QC 8 - 4

QC 8 - 44

QC 8 - 45

QC 8 - 49

QC 8 - 58

QC 8 - 8

QC 8 - 9

QC 8 - 68

QC 8 - 67

QC 8 - 1 (A)

QC 8 - 47

QC 8 - 40

QC 8 - 52

QC 8 - 23

QC 5 - 10

QC 5 - 12

QC 5 - 17

QC 5 - 18

QC 5 - 19

QC 5 - 22

QC 5 - 24

QC 5 - 3

QC 5 - 43

QC 5 - 49

QC 5 - 51

QC 5 - 58

QC 5 - 68

QC 5 - 9

QC 5 - 50

QC 5 - 30

QC 5 - 40

140 QC 5

10 pcs

5/3/19

0.00 0.00

QC 5 - 10

QC 5 - 12

QC 5 - 17

QC 5 - 18

QC 5 - 19

QC 5 - 22

QC 5 - 24

QC 5 - 3

QC 5 - 43

QC 5 - 49

QC 5 - 51

QC 5 - 58

QC 5 - 68

QC 5 - 9

QC 5 - 50

QC 5 - 30

QC 5 - 40

150 Outsource - 12 - Black Oxide 10 pcs

5/3/19

GRO002-VC

5

160 Packaging 2-1 - Receive - B4B 10 pcs

5/3/19

0.00 0.00

Packaging 2 - 1 - B4B

Packaging 2 - 2 - B4B

Packaging 2 - 3 - B4B

Packaging 2 - 5 - B4B

Packaging 2 - 4 - B4B

Packaging 2 - 6 - B4B

Packaging 2 - 7 - B4B

Packaging 2 - 8 - B4B

Packaging 2 - 9 - B4B

Packaging 2 - 10 - B4B

Packaging 2 - 11 - B4B

Packaging 2 - 12 - B4B

Packaging 2 - 13 - B4B

Packaging 2 - 14 - B4B

Packaging 2 - 15 - B4B

m 19/06/18

H 2019-06-21

JUL 03 2019

				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
170 QC 6	10 pcs	5/3/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	DAS
				QC 6 - 61	61
				QC 6 - 40	9-89
180 Packaging 3-1 - Stock - B4B	10 pcs	5/3/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	DAS
				Packaging 3 - 6 - B4B	28
				Packaging 3 - 7 - B4B	9-89
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	

				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	10 pcs	5/3/19	0.00 0.00	QC 21 - SA - 21	JUL 05 2019
				QC 21 - SA - 70	DAG
				QC 21 - SA - 53	21

Part Op 110 - (MORI SL-154 LATHE), 1-Machine as per DWG. FB788 FOLIO REV: AA DWG REV: 6 2-
 Descriptions: Deburr 3-Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG.
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (QC5- Inspect part completeness to step on W/O)
 150 - -Issue P/O; PO 43821 -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required
 160 - (Receive & Inspect for Damage & Mat'l Certs)
 170 - (QC6- All purchased or subcontracted products)
 180 - (Identify as per dwg & Stock Location: _____)
 190 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
MT-A513-T-0.750W0.058	A513 Seamless Alloy Steel Round Tubing 0.75"dia. x 0.058" Wall	3.7800 ft (.378 ea)	110-SL-154 - 1	<u>5107503</u>

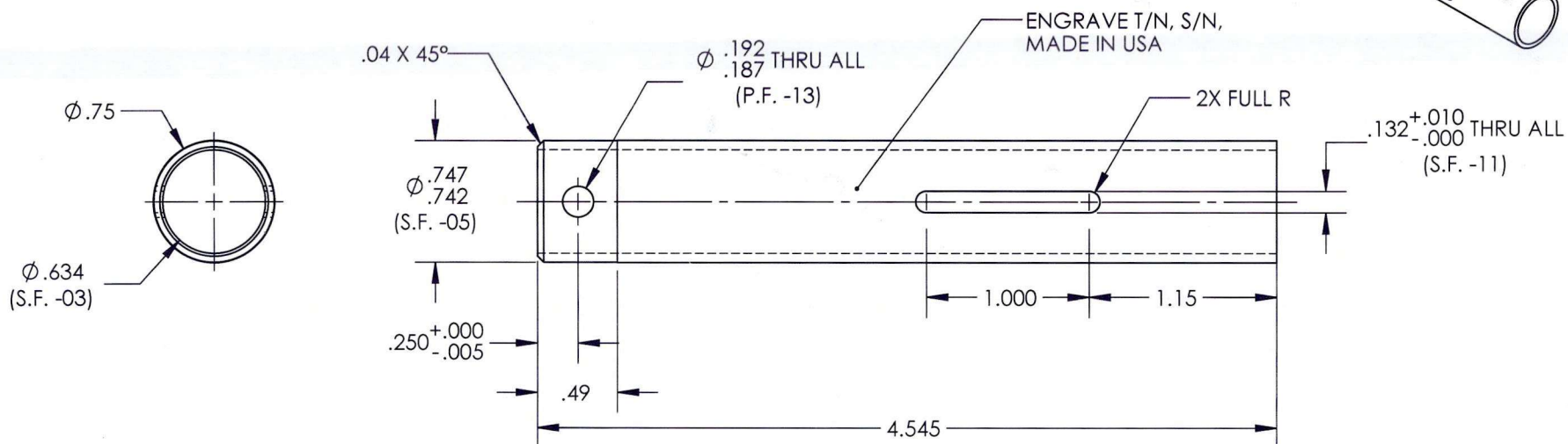
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-SL-154 - 1	MT-A513-T-0.750W0.058	4	80	0

Part Specifications
Specifications could not be found.

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
5	15-0213	-01 CH'D HOLE WAS Ø5.1 mm IS Ø.192 - .187.	8/14/2015	RJC	JAG
6	16-0286	-01 CH'D DIM WAS Ø.620 S.F. -03 IS Ø.634 (S.F. -03), WAS .250 IS .250 +.000/-005, WAS .130 THRU IS .132 +.010/-000 (S.F. -11), WAS Ø.192/.187 THRU IS Ø.192/.187 THRU ALL (P.F. -13), DELETED DIM Ø.750 ∇ .47 MIN S.F. -05, ADDED DIM Ø.747/.742 (S.F. -05), .49, 2X FULL R, ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D.	2/28/2017	RJC	SM



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

(-01)

TUBE

NO. 193408 MJS/
1904-15

DART AEROSPACE	
TITLE SWASHPLATE IMMOBILIZING TOOL ADJUSTABLE BRACE	
DWG NO. RBE350A94-3700-C-01	REV 6
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH BLACK OXIDE	.XX ± .01 ANGLES ± 5°
SPEC QMSI-6.2.2, B.O. REV D	.X ± .1 SURFACES = 125/✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: MACKOVJAK	EUROCOPTER AS350/355
SCALE 1:1	DATE 8/21/2012 SHEET 3 OF 7



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB043821



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043821
PO Date: 6/21/19
Due Date: 7/2/19
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground
Pymt Terms: Net 60

Freight Terms:
Special Comments:

E-MAILED
2019-06-25

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	195964	RB877206-5-27	Bolt Outsource12 (Outside Processing - Black Oxide) -Issue P/O to Groupe Altech -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	7/2/19	8 pcs	0 pcs	8 pcs	\$0.99/pcs	\$7.92
2	196580	RBA8100-80902-300	Weldment -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required	Firmed	-	7/2/19	2 pcs	0 pcs	2 pcs	\$3.15/pcs	\$6.30
3	193350	RBE350A94-3700-B-01	Tube (Outside Processing - Black Oxide) -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	7/2/19	45 pcs	0 pcs	45 pcs	\$3.55/pcs	\$159.75



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PURCHASE ORDER

POHB043821



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	193408	RBE350A94-3700-C-01	Tube -Issue P/O -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	7/2/19	27 pcs	0 pcs	27 pcs	\$1.88/pcs DAS 61 9-89	\$50.76
Grand Total:											\$224.73

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 6/25/19 3:45 PM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(020269-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

020269- 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
03-Jul-2019		SVETLANA DORZHIYEVA		POHB043821				
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RB877206-5-27 Rev.	RB877206-5-27 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	8	8	0	0	0
2	RBA8100-80902-300 Rev.	RBA8100-80902-300 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C, CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 ANS WIPE OF EXCESS	OXIDE-BLACK CH	2	2	0	0	0
4	RBE350A94-3700-C-01 Rev.	RBE350A94-3700-C-01 01 - BLACK OXIDE MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	27	27	0	0	0

DAS
61
9-89

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DAS
61
9-89

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 JUL 03 2019
 DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					